

2/02/2009 11:50:00 AM

on

Process Sheet

U-DAR001 Dart Helicopters Services

Drawing Name : CONSOLE SIDE LH (206 HI-SLOPE)

1390

Part Number : 11000

P.O. Number :

Part Number : D26021 *D2602-1*

This Issue : 02/02/2009

S.O. No. :

Drawing Number : D2602 REV B

Prsht Rev. : NC

Project Number : N/A

First Issue : / /

Type : SMALL /MED FAB

Drawing Revision : B

Previous Run : 44391

Material :

Due Date :

12/02/2009

Qty:

6 Um:

Each

Written By :

Checked & Approved By :

Comment :

: Est. D 04.02.25 Reformat KJ/RF

Note: Issue with part number D2602-2

Est Rev:E Now On Waterjet 07-03-22 JLM

Est Rev:F RevB as per dwg ECN1059 DD verified by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S040

2024-T3 .040 sheet



Comment: Qty.: 1.4146 sf(s)/Unit Total : 8.4874 sf(s)

2024-T3 .040 sheet

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040) Batch *110337* *B9-2-12*

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2602

*****Same Cutting File for -1 & -2 *****

Dwg Rev: *B*Prog Rev: *B**B9-2-12*

2-Deburr if necessary

B9-2-12

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

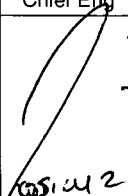
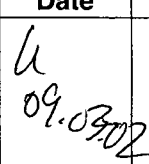
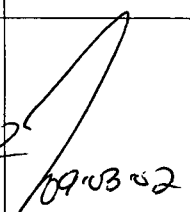
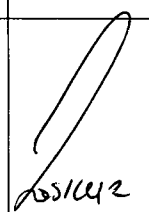
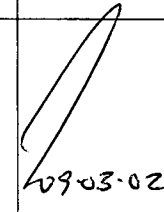


Comment: SECOND CHECK

*809103/04**(x6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2601-1 PAR #: N/A Fault Category: Prod/Eng - Coordination NCR: Yes No DQA: D Date: 09/03/12
 Resolution: Process Reused Disposition: Re-work QA: N/C Closed: D Date: 09/03/12

NCR: <u>45390</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-03-02	2.0	Incorrect parts made. D2602 AS D2601. Employee worked off of the drawing the incorrect dwg was attached to the W/O. Affected W/O's are: 45390, 44391, 45391, 44392		- See NCR 09-027 - update W/O to a D2601				

NOTE: Date & initial all entries

Date: Monday, 02/02/2009 11:50:00 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 45390

Part Number: D26021

D2601-1

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D2602

SB 09/03/04 (6)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/06 (+6) (-1)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AMP/BK

(X6) 09/03/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D.M. 09.03.06

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/3/10

SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10

Job Completion



MF 09-03-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	45390
Description: CONSOLE SIDE		Part Number:	D2601-1
Inspection Dwg: D2601-1 Rev: B		Page 1 of 1	

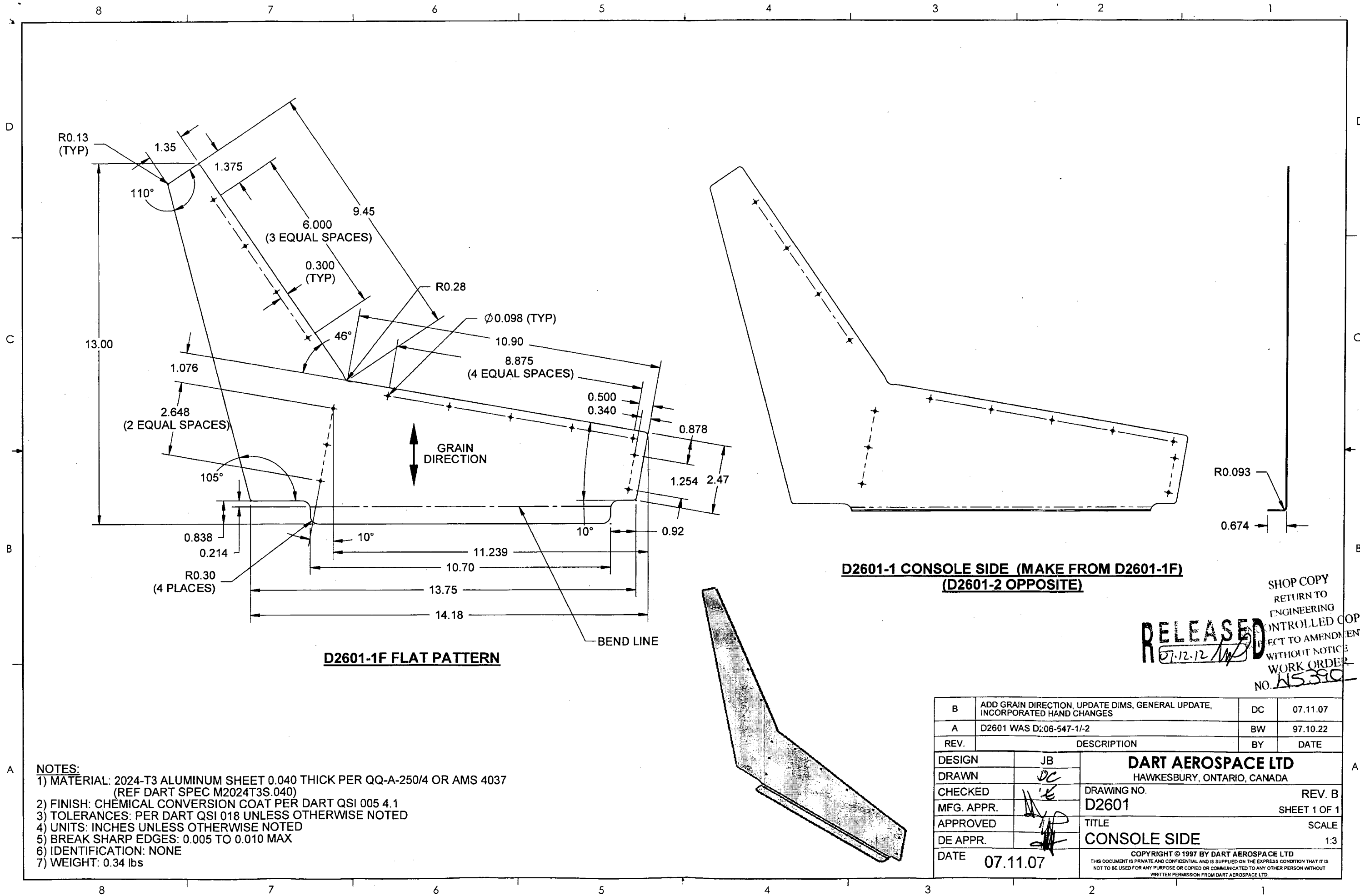
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	X			
13.00	+/- .030	12.981	X			
1.35	+/- .030	1.352	X			
1.375	+/- .010	1.372	X			
.300	+/- .010	.301	X			
6.000	+/- .010	5.994	X			
9.45	+/- .030	9.45	X			
10.96	+/- .030	10.90	X			
8.875	+/- .010	8.878	X			
.340	+/- .010	.338	X			
.500	+/- .010	.500	X			
.875	+/- .010	.880	X			
1.254	+/- .010	1.247	X			
2.47	+/- .030	2.483	X			
.92	+/- .030	.911	X			
11.239	+/- .010	11.221	X			
10.76	+/- .030	10.694	X			
13.75	+/- .030	13.75	X			
14.18	+/- .030	14.18	X			
.838	+/- .010	.838	X			
2.648	+/- .010	2.650	X			
.640	+/- .010	.640	X			

Measured by: RB	Audited by: S	Prototype Approval: N/A
Date: 9-3-3	Date: 09/03/04	Date: 1/04

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D2601-1 CONSOLE SIDE (MAKE FROM D2601-1F)
(D2601-2 OPPOSITE)

D2601-1F FLAT PATTERN

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.34 lbs

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45390

RELEASED
07.12.12

B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES	DC	07.11.07
A	D2601 WAS D206-547-1/2	BW	97.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	JE	DRAWING NO.	REV. B
MFG. APPR.		D2601	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CONSOLE SIDE	1:3
DATE	07.11.07	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	